

Work Order ID 112437

\*112437\*

Page 1

January-30-14 11:43:22 AM

Item ID: D2654-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Web

Start Date: 1/24/14 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 1/30/14 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date: 1-02-03

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2654

F

100

0.00

\*100\*

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2654  
2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654  
3-Using the uni-bit, open holes to finish size as per Dwg D2654  
4-Deburr holes and ends

120

Chemical Conversion Coat per QSI005 4.1

0.00

\*120\*

HandFinish

Memo

0.00

Hand Finishing

130

QC5- Inspect part completeness to step on W/O

0.00

\*130\*

QC

Memo

0.00

Quality Control

14-3-27 JLB

4 MB 14-3-28

DAS  
03  
9-89

DP 14-4-2

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 112437**

January-30-14 11:43:22 AM

**\*112437\***

Page 2

Item ID: D2654-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Web

Start Date: 1/24/14

Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 1/30/14

Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Identify as per dwg & Stock Location: 46

0.00

**\*140\***

Packaging

Memo

0.00

Packaging

(4) [Signature] 14-4-2

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

14-04-2

(H) 14-04-02

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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# Picklist Print

January-30-14 11:43:21 AM

Page 1

Work Order ID: 112437

Parent Item: D2654-1

Parent Item Name: Web

Start Date: 1/24/14

Required Date: 1/30/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM  
IPP Rev:E 08-06-10 revE1 as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-080 Extrusion 'I Beam' thin		Manufactured	No				Each	0.0000		4			
D2600-5-108						B 105 417							

4

DAS  
10  
9-88

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Operator									
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Process									
Supplier									
Training									
Transport									
Unapproved									

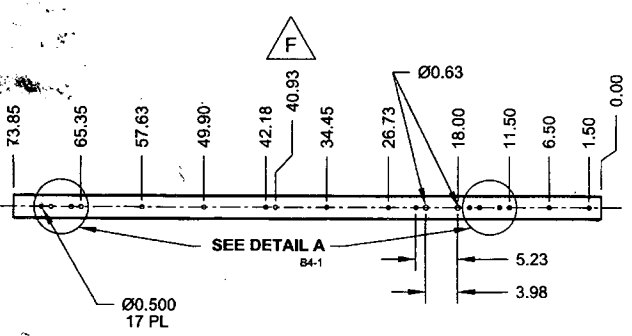
### FAULT CATEGORY

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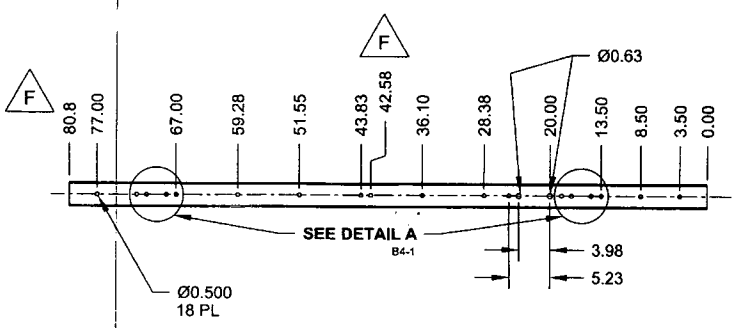
8 7 6 5 4 3 2 1

D  
C  
B  
A

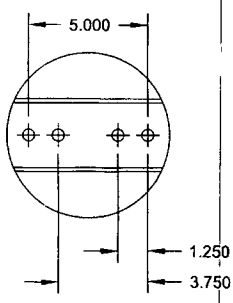
D  
C  
B  
A



**D2654-1 WEB**



**D2654-3 WEB**



**DETAIL A**

C2-1  
C3-1  
C6-1  
C8-1  
D3-2  
D6-2  
B3-2  
B6-2

112 437 NO  
14-02-03

**RELEASED**  
2011-09-12

- NOTES:**
- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
  - 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs  
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHV HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	CP		
MFG. APPR.	CP		
APPROVED	CP		
DE APPR.	CP	DRAWING NO. D2654 TITLE WEB SCALE NTS	
DATE	11.05.05	REV. F SHEET 1 OF 2	

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